



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3915-041
Job Sheet 189954



Part No: D3915-041

Job Qty: 1 pcs

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	2/15/19		0.00	3.33	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	2/15/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS 24 9-89
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	1 pcs	2/15/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		DAS 24 9-89
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

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					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
130	Handfinish - 1-1 Chemical- B4B	1 pcs	2/15/19	0.00 1.00	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	DR 19/2/19
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	Large Fab - Welded Assy-2-B4B	1 pcs	2/15/19	0.00 3.33	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	C
					Large Fab - 8 - B4B	
150	QC 9	1 pcs	2/15/19	0.00 0.00	Large Fab - 9 - B4B	
					QC 9 - 10	
					QC 9 - 18	DAS 24 9-89
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
155	QC 5	1 pcs	2/15/19	0.00 0.00	QC 9 - 9	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	DAS 24 9-89
					QC 5 - 18	
					QC 5 - 19	

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				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
157 Handfinish - 1-2- Chemical-B4B	1	2/15/19	0.00 1.00	Handfinish - 1 - 1 - B4B	
pcs				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/2/21
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White Gl(A)- B4B	1	2/15/19	0.00 0.83	Powdercoat - 1 - B4B	
M138997	pcs			Powdercoat - 2 - B4B	
START: 9:25 OUT: 300° FINISH: 9:55				Powdercoat - 3 - B4B	DR 19-2-21
				Powdercoat - 4 - B4B	
170 QC 3	1	2/15/19	0.00 0.00	QC 3 - 10	
pcs				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	

				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
180	Handfinish - 4-1-Assembly-B4B	1 pcs	2/15/19	0.00 0.81	Handfinish - 4 - 1 - B4B
					Handfinish - 4 - 10 - B4B
					Handfinish - 4 - 11 - B4B
					Handfinish - 4 - 12 - B4B
					Handfinish - 4 - 13 - B4B
					Handfinish - 4 - 14 - B4B
					Handfinish - 4 - 15 - B4B
					Handfinish - 4 - 2 - B4B
					Handfinish - 4 - 3 - B4B
					Handfinish - 4 - 4 - B4B
					Handfinish - 4 - 5 - B4B
					Handfinish - 4 - 6 - B4B
					Handfinish - 4 - 7 - B4B
					Handfinish - 4 - 8 - B4B
					Handfinish - 4 - 9 - B4B
190	QC 5	1 pcs	2/15/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 38
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
200	Packaging 3-1 - Stock - B4B	1 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B

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				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	BEB 19-02-21
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	1 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	FEB 21 2019
				QC 21 - SA - 53	

Part Op **100** - (Weld per dwg A/R Aluminum rod Batch: _____) 1- assemble ribs , weld as per dwg D3915 using DT9606A. When Descriptions: welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O) -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4

130 - (Chemical Conversion Coat per QSI005 4.1) ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***

140 - (Weld per dwg A/R Aluminum rod Batch: _____) 1- weld (4) corners

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

155 - (QC5- Inspect part completeness to step on W/O) ***inspect fit of lid with base***

157 - (Chemical Conversion Coat per QSI005 4.1) 1- realodine corners ***do not acid etch***

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 1- touch up corner with alodine only 2- Plug holes prior to finish 3- Mask this area prior to finish View B-B 1ST COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Assemble as per dwg) 1- Install webbing as per dwg 2- Install placard and label as per dwg

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2957 ✓	Mounting Plate	4 pcs (4 ea) ✓	100-Large Fab - Welded Assy-1	5083647
D3915-1 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5144789
D4016-5 ✓	Hinge Half, Light Lid	3 pcs (3 ea) ✓	100-Large Fab - Welded Assy-1	5039258
D4019-3 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Welded Assy-1	5094469
D4035-047 ✓	Lid Rib Assembly, Aft (Light)	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	5141900
D4056-1 ✓	Label Plate	1 pcs (1 ea) ✓	100-Large Fab - Welded Assy-1	5067108
D2728-1	Dart Logo Label Small	1 pcs (1 ea)	180-Handfinish - 4-1-Assembly-B4B	
D4029-041	Webbing (Long Basket)	1 pcs (1 ea)	180-Handfinish - 4-1-Assembly-B4B	5149900
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-Handfinish - 4-1-Assembly-B4B	5141237-1
NAS1149DN949J	Washer	34 Ea (34 ea)	180-Handfinish - 4-1-Assembly-B4B	55050054/29x507 1414-2
				M.U. 008259

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2957	4	37	0
	D3915-1	2	10	0
	D4016-5	3	20	0
	D4019-3	3	11	0
	D4035-047	2	4	0
	D4056-1	1	12	0
180-Handfinish - 4-1-Assembly-B4B	D2728-1	1	0	0
	D4029-041	1	4	0
	MS20600-AD4W4	34	4,243	0
	NAS1149DN949J	34	278	0



Container No: S154107



Part: D3915-041

Job No: 189954

Serial No/Batch: S154107

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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cifications

ould not be found.

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D3915-041
Job Sheet 189954



Part No: D3915-041

Job Qty: 1 ea

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs		2/15/19	0.00	3.33	Large Fab 2		
110	QC	1 pcs		2/15/19	0.00	0.00	QC9		
120	QC	1 pcs		2/15/19	0.00	0.00	QC5		
130	HandFinish	1 pcs		2/15/19	0.00	1.00	HandFinish1		
140	Large Fab	1 pcs		2/15/19	0.00	3.33	Large Fab 2		
150	QC	1 pcs		2/15/19	0.00	0.00	QC9		
155	QC	1 pcs		2/15/19	0.00	0.00	QC5		
157	HandFinish	1 pcs		2/15/19	0.00	1.00	HandFinish1		
160	Powdercoat	1 pcs		2/15/19	0.00	0.83	Powdercoat1		
170	QC	1 pcs		2/15/19	0.00	0.00	QC3		
180	HandFinish	1 pcs		2/15/19	0.00	0.81	HandFinish4		
190	QC	1 pcs		2/15/19	0.00	0.00	QC5		
200	Packaging	1 pcs		2/15/19	0.00	0.00	Packaging3-2		
210	QC21-SA	1 Ea		2/15/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make Descriptions: a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915
 120 - -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4
 130 - ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***
 140 - 1- weld (4) corners
 155 - ***inspect fit of lid with base***
 157 - 1- realodine corners ***do not acid etch***
 160 - 1- touch up corner with alodine only 2- Plug holes prior to finish 3-Mask this area prior to finish View B-B 1ST COAT:
 START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ ***** 2nd
 coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 180 - 1- Install webbing as per dwg 2- Install placard and label as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2957	Mounting Plate	4 pcs (4 ea)	90-Start up Operation	
D3915-1	Rib	2 pcs (2 ea)	90-Start up Operation	
D4016-5	Hinge Half, Light Lid	3 pcs (3 ea)	90-Start up Operation	
D4019-3	Rib	3 pcs (3 ea)	90-Start up Operation	
D4035-047	Lid Rib Assembly, Aft (Light)	2 pcs (2 ea)	90-Start up Operation	
D4056-1	Label Plate	1 pcs (1 ea)	90-Start up Operation	
D2728-1	Dart Logo Label Small	1 pcs (1 ea)	180-HandFinish	
D4029-041	Webbing (Long Basket)	1 pcs (1 ea)	180-HandFinish	
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-HandFinish	
NAS1149DN949J	Washer	34 Ea (34 ea)	180-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2957	4	37	0
	D3915-1	2	10	0
	D4016-5	3	20	0
	D4019-3	3	11	0
	D4035-047	2	4	0
	D4056-1	1	12	0
180-HandFinish	D2728-1	1	0	0
	D4029-041	1	5	0
	MS20600-AD4W4	34	4,278	0
	NAS1149DN949J	34	308	0

Part Specifications

Specifications could not be found.

Plex 2/1/19 9:32 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					